

Work Order ID 86318

86318

Page 1

June-27-12 9:51:24 AM

Item ID: D3411-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: WASHER

Start Date: 27/06/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/27 Tooling:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

100

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA591 Rev: AA & Dwg D3411 Rev: A
Deburr & Tumble as per Dwg D3411

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>042</u>	0.00							
130									
Packaging	Memo	0.00				56			12/07/03/B
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							12/17/44
Quality Control									

110074

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

June-27-12 9:52:22 AM

Page 1

Work Order ID: 86318

86318

Parent Item: D3411-3

D3411-3

Parent Item Name: WASHER

Start Date: 27/06/2012

Required Date: 04/07/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A05.10.19New issueKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.000		Purchased	No			100	f	23.3202	0.0136	0.715789			

MDFI RINR1 000

Delrin Round Bar 1"

**

12-7-2

Location

Loc Qty

Loc Code

MAT055

23.3202

117985

0.407

118392

6.2762

119306 ✓

16.637

7

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

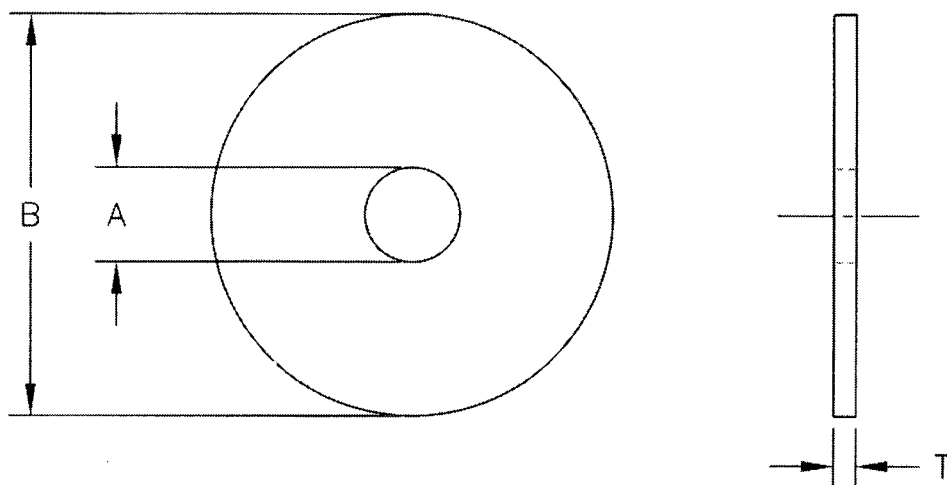
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3411	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE WASHER, DELRIN	SCALE NTS
A	05.03.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



- 1) SPECIFICATION: **D3411-X WASHER**
DASH No.

RELEASED
05.07.06 *[Signature]*

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH NO.	BOLT SIZE	A (in)	B (in)	T (in) ±0.006	NON-METALLIC REPLACEMENT FOR:
-3	#10	0.203	0.875	0.063	AN970-3
-4	1/4	0.265	1.125	0.063	AN970-4
-5	5/16	0.328	1.375	0.063	AN970-5
-6	3/8	0.390	1.625	0.063	AN970-6
-7	7/16	0.453	1.812	0.109	AN970-7
-8	1/2	0.515	2.000	0.109	AN970-8

- 2) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
 3) FINISH: NONE
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES

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 WITHOUT NOTICE
 WORK ORDER
 NO. 26310415
 12/26/27

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